

Date: Friday, 10/10/2008 12:57:03 PM  
 User: Julie Lecocq

## Process Sheet

|                                    |  |                           |                       |
|------------------------------------|--|---------------------------|-----------------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b> :     | 350/355 AS X-TUBE AFT |
| <b>Job Number</b> :                | 42538  |                           |                       |
| <b>Estimate Number</b> :           | 12486  |                           |                       |
| <b>P.O. Number</b> :               |  | <b>Part Number</b> :      | D350748201            |
| <b>This Issue</b> :                | 10/10/2008   | <b>Drawing Number</b> :   | N/A                   |
| <b>Prsht Rev.</b> :                | NC   | <b>Project Number</b> :   | N/A                   |
| <b>First Issue</b> :               | 1/1  | <b>Drawing Revision</b> : | D                     |
| <b>Previous Run</b> :              | 42537  | <b>Material</b> :         |                       |
| <b>Written By</b> :                |  | <b>Due Date</b> :         | 22/10/2008            |
| <b>Checked &amp; Approved By</b> : | JLD 08-10-10   | <b>Qty:</b>               | 1 Um: Each            |
| <b>Comment</b> :                   | Est Rev: A New Issue 06-07-05 JLM<br>Est Rev: B Update qty of MS21042L5 06-09-12 KJ<br>Est Rev C Combined manufacturing 08.04.02 EC verified by:<br>DD<br>Est Rev:D 08-06-24 revD as per dwg DD verified by:EC |                           |                       |

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



**Comment:** Photocopy bluefile & type labels per PPPD350-748-201 CHG001

2.0

D350748241TRN

Crosstube Turning Detail



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 CROSSTUBE TURNING DETAIL  
 batch B42484

MB 08-11-19

3.0

BENDING

BENDING MACHINE - SKIDTUBES

**Comment:** BENDING MACHINE

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

MB 08-11-19

4.0

QC15

DIMENSIONAL CHECK OF X-TUBES

**Comment:** DIMENSIONAL CHECK OF X-TUBES

MB 08-11-24

5.0

CROSSTUBES

CROSSTUBES RESOURCE 1

**Comment:** LANDING GEAR RESOURCE 1

1-Remove all marks from tube within limits of D350-748-241

2-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,  
 Set-up drill table as per QSI 010

ANM 5-11-2C  
 MB 08-11-26

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Friday, 10/10/2008 12:57:03 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 42538

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Deburr

5- Apply CP3 Batch: m109539- Fx 08/11/27 MB 08-11-26  
4-Engrave Part # and Batch # as per Dwg D350-748-241

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

56/627 @

7.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 7700

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

CL08/11/27  
①

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

8/12/22 ①  
08-12-23 @

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Paint Outside of Tube as per Dart QSI 005 4.2

27 08-12-23

11.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

08 12 24 -①

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 10/10/2008 12:57:03 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 42538

Part Number: D350748201

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|      |          |                |
|------|----------|----------------|
| 12.0 | D2856400 | Abraison Strip |
|------|----------|----------------|



Comment: Qty.: 1.2401 f(s)/Unit Total : 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: 37667

ml 08 12 29

|      |             |        |
|------|-------------|--------|
| 13.0 | ALS41032225 | Insert |
|------|-------------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: 109817

ml 08 12 29

|      |           |        |
|------|-----------|--------|
| 14.0 | AN960JD10 | Washer |
|------|-----------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

Batch: 105442

ml 08 12 29

|      |           |                           |
|------|-----------|---------------------------|
| 15.0 | MS2192020 | Clamp (per MIL-DTL-8783C) |
|------|-----------|---------------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 109715

ml 08 12 29

|      |            |       |
|------|------------|-------|
| 16.0 | MS27039110 | Screw |
|------|------------|-------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

Batch: 18836

ml 08 12 29

|      |            |                       |
|------|------------|-----------------------|
| 17.0 | CROSSTUBES | CROSSTUBES RESOURCE 1 |
|------|------------|-----------------------|



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS

ml 08 12 29 (1)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 10/10/2008 12:57:03 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 42538

Part Number: D350748201

Job Number:



Seq. #: Machine Or Operation: Description :

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.12.30 ①  
CHECKED FOR FLATNESS → UNACCEPTABLE #2903.25

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

20.0

D35001

Saddle



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
350 SADDLE  
Batch: 1341555 41602 ②

21.0

D35021

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
SUPPORT  
Batch: 42968 ml 08 12 29

PTD

22.0

D35011

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)  
BUSHING  
Batch: 1339726

23.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)  
Bolt  
Batch: M109545

24.0

AN441A

bolt





Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)  
bolt  
Batch: M109068 ②

M109032 ⑥

8/12/30

SP

| W/O:     |      | WORK ORDER CHANGES                               |    |      |     |   |   |  |
|----------|------|--|----|------|-----|---|---|--|
| DATE     | STEP | PROCEDURE CHANGE                                 | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr   | Approval<br>QC Inspector  |  |
| 06-12-30 | 210  | D3502-1 goes in the Assy pick list. param change |    |      |     |  |  |  |
|          |      |  |    |      |     |   |   |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 42538

Part Number: D350748201

Job Number:



Seq. #: Machine Or Operation: Description :

25.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109752

26.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch: M109249

27.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M109752

28.0

MS21042L4

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch: M108145

29.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M109297

30.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-201

Location:

PPP Rev: Dneft

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 10/10/2008 12:57:03 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 42538

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①  
D09/01/06  
mf 09-01-06

Job Completion



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

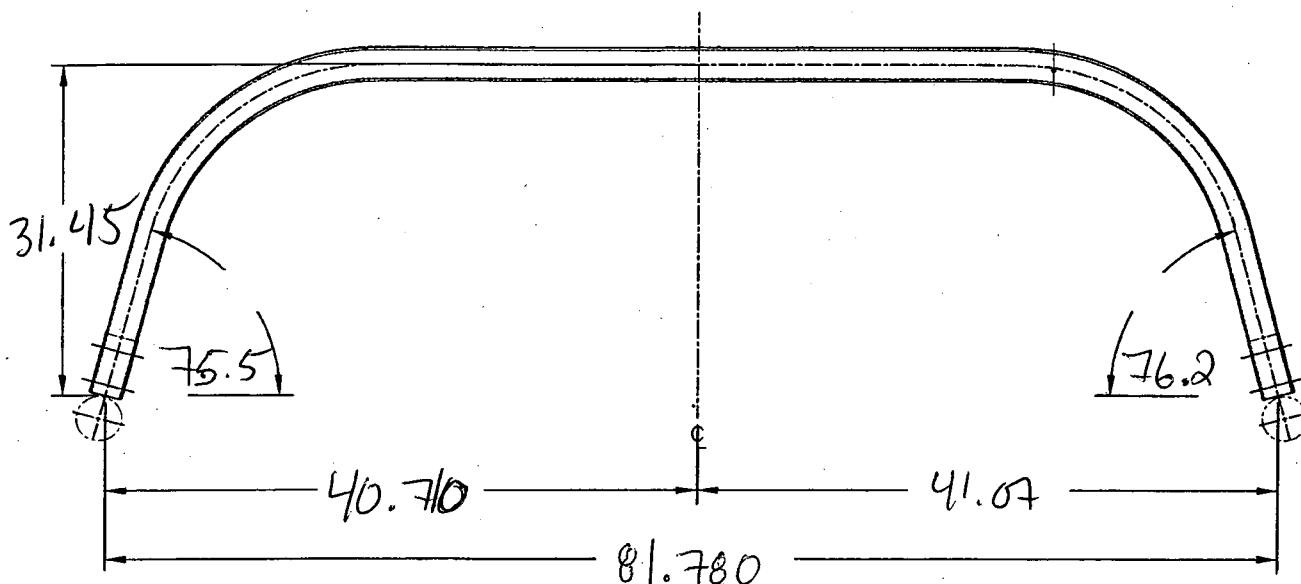
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|   |  |                           |
|---|--|---------------------------|
| DART AEROSPACE LTD                          |  | Work Order: 42538         |
| Description: Crosstube High Aft (AS350/355) |  | Part Number: D350-748-201 |
| Inspection Dwg: D350-748-241 Rev: D         |  | Page 1 of 1               |

| Required Dimension | Min   | Max   |
|--------------------|-------|-------|
| Height             | 31.22 | 31.48 |
| 1/2 Span           | 40.77 | 41.03 |
| Angle              | 75    | 77    |
| Total Span         | 81.54 | 82.06 |



| Comments                                   |
|--|
| MAX TWIST = 0.708" → UNACCEPTABLE 09.03.25 |
|  |
|  |

|                 |          |
|-----------------|----------|
| QC15 Inspection |          |
| Date            | 08.11.24 |

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 07.02.06 | New Issue | KJ/JM      |          |

**DART****RELEASED**

06.10.31

|                  |                |  |                        |
|------------------|----------------|--|------------------------|
| DESIGN<br>QP     | DRAWN BY<br>QP | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>H     | APPROVED<br>H  | DRAWING NO.<br>D350-748-241                              | REV. D<br>SHEET 1 OF 3 |
| DATE<br>06.10.31 |                | TITLE<br>CROSSTUBE (AS 350/355 HI AFT)                   | SCALE<br>NTS           |
| A                | 06.03.31       | NEW ISSUE  |                        |
| B                | 06.06.30       | ADD D6018-125 & PRIME AND PAINT                          |                        |
| C                | 06.08.14       | ADD CAD PLATING  |                        |
| D                | 06.10.31       | MAG. PARTICLE AND CAD PLATE AS MFD.                      |                        |

| QTY | P/N           | DESCRIPTION                            |
|-----|---------------|--|
| X   | D350-748-241  | CROSSTUBE ASSEMBLY (AS 350/355 HI AFT) |
| 1   | D6018-125     | CROSSTUBE (OR D6015-125)               |
| 2   | D3502-1       | SUPPORT                                |
| 2   | D2856-400-710 | ABRASION STRIP                         |
| 1   | AELS-1032-225 | INSERT                                 |
| 1   | AN960JD10     | WASHER                                 |
| 2   | MS21920-20    | CLAMP (PER DART SPEC. M-MS21920-20)    |
| 1   | MS27039-1-10  | SCREW                                  |

**D350-748-141 CROSSTUBE:**

- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125  
FINISHED LENGTH = 122.70±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

**UNDER REVIEW**

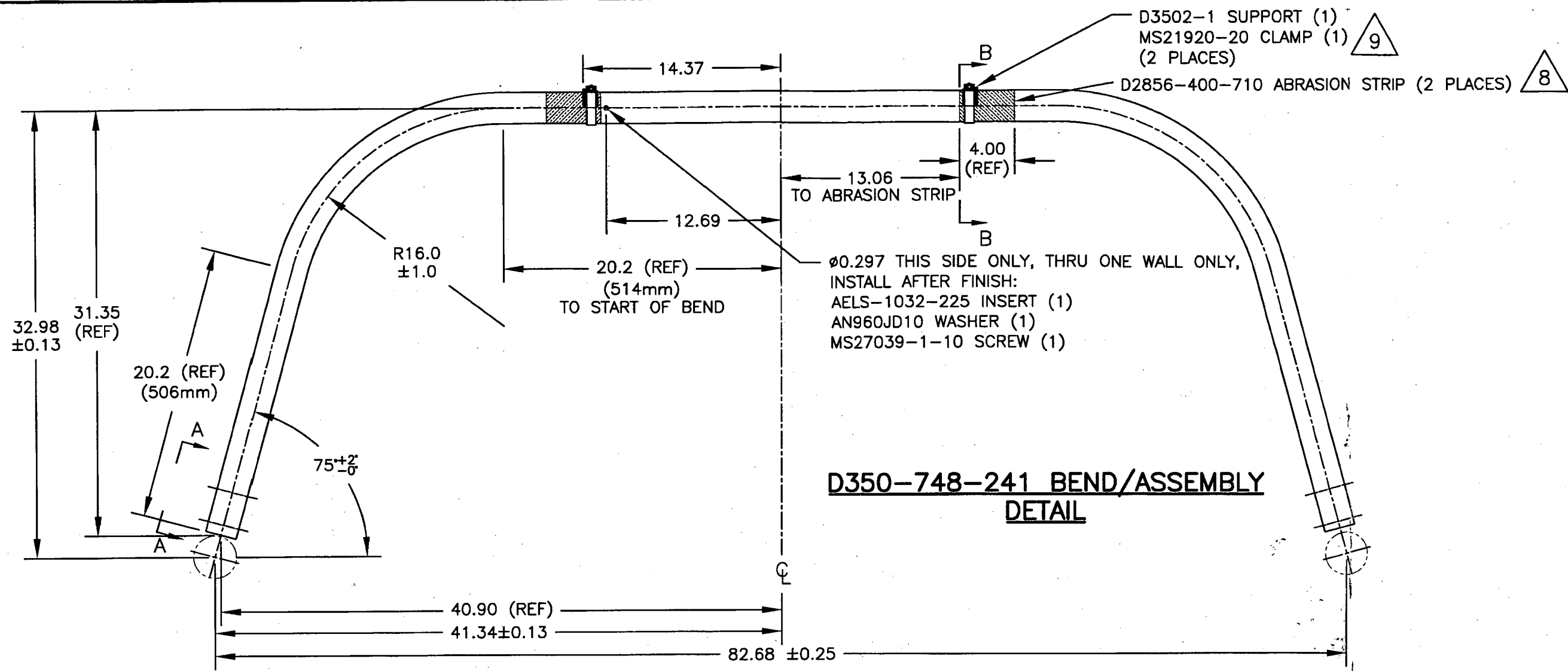
07.02.16

0.07 0.04 REDUCED

X 07.07.22

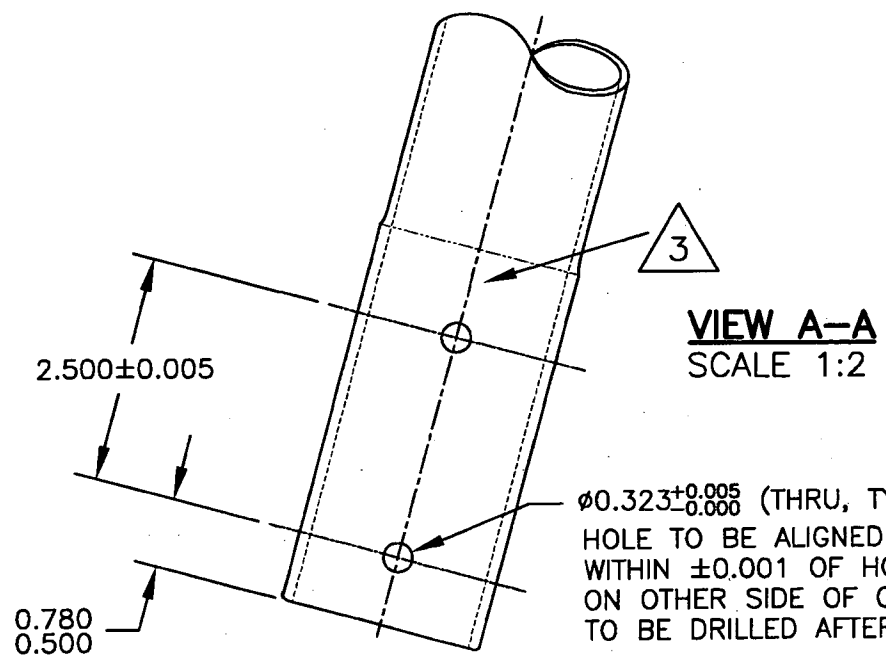
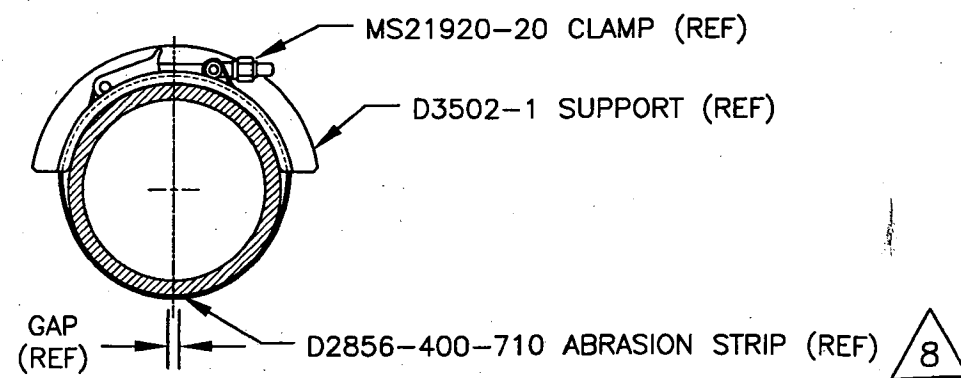
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# **D350-748-241 BEND/ASSEMBLY DETAIL**

## **SECTION B-B SCALE 1:2**



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

**UNDER REVIEW**

07.02/16/11  
CUFF (REF) (REF)

**RELEASED**

06.10.31

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AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

DESIGN

DRAWN BY

**DART**

**DART AEROSPACE LTD.**  
HAWKESBURY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.  
D350-748-241

REV. D

DATE

TITLE

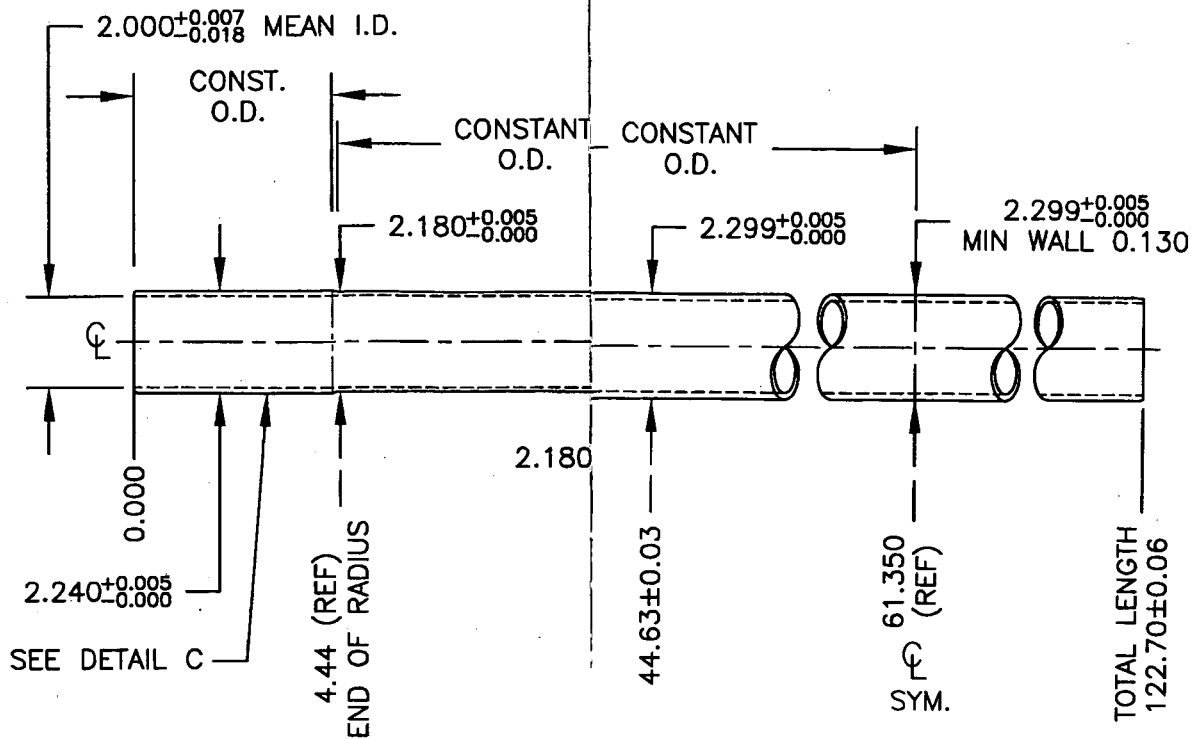
SCALE

06.10.31

CROSSTUBE (AS 350/355 HI AFT)

1:8

SHEET 2 OF 3



0.063  
MIN

CHAMFER AS REQUIRED  
FOR TOOLING LEAVING  
0.062 (REF) MIN EDGE  
DISTANCE. ENSURE  
CHAMFER TOOL PATH  
RUNS OFF I.D.

R0.063

R0.50

R0.063

4.2<sup>WN</sup> BY  
TU

**UNDER REVIEW**

07.02/16/11

CUFF BEG. REDUCED  
OK CP07.N 22

2.180 (REF)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42538

**DETAIL D:  
CUFF TRANSITION  
SCALE 9:1**

**RELEASED**

06.10.31

**DART**

**DART AEROSPACE LTD.**  
HAWKESBURY, ONTARIO, CANADA

APPROVED

DRAWING NO.  
D350-748-241

REV. D

SHEET 3 OF 3

TITLE  
CROSSTUBE (AS 350/355 HI AFT)

SCALE

1:4





# Packing Slip



## Cadorath Plating Co. Ltd.

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

**INVOICE NUMBER:**

42387

**Sold To:**

Dart Aerospace Ltd.  
1270 Aberdeen St.

Hawksbury, ON K6A 1K7

**ShipTo:**

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

| Customer Order #: | Date Received: | Terms:      | G.S.T. #:         | Ship Via: | Ship Date:  |
|-------------------|----------------|-------------|-------------------|-----------|-------------|
| 00007700          | Dec-08-2008    | NET 30 DAYS | 10071 6547 RT0001 |           | Dec-17-2008 |

**Item # Qty P/N & Description**

|   |      |                  |            |
|---|------|------------------|------------|
| 1 | 1 EA | SKID             | S/N B43336 |
|   |      | P/N d350-748-101 | W/O 82376  |
| 2 | 1 EA | SKID             | S/N B43337 |
|   |      | P/N d350-748-101 | W/O 82377  |
| 3 | 1 EA | SKID             | S/N B43339 |
|   |      | P/N d350-748-101 | W/O 82378  |
| 4 | 1 EA | SKID             | S/N B42538 |
|   |      | P/N d350-748-101 | W/O 82379  |

**CERTIFICATE OF  
CONFORMANCE**

**CADORATH PLATING CO. LTD.  
2150 LOGAN AVENUE  
WINNIPEG, MANITOBA R2J-0J1**

**DATE:** Dec-17-2008

**CONIGNED TO:** Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawksbury, ON K6A 1K7

**W/O #:** 82379  
**INVOICE #:** 42387

**CONTRACT OR  
PURCHASE ORDER # 00007700**

**DESCRIPTION:** SKID

**QTY** 1

**P/N #** d350-748-201

**S/N #** B42538

**STRESS RELIEF BAKE @ 375 FOR 5 HRS HEAT CHART # 9921. MPI  
INSPECTED IAW ASTM E 1444. CADMIUM PLATED IAW AMS-QQ-P-  
416B, TYPE 2 YELLOW, CLASS 2. BAKE HEAT CHART # 9967.**

**CERTIFICATE: I certify that the items indicated here on have  
been inspected and tested and conform to all specifications  
and requirements detailed on the contract or purchase order.**

**Approved Inspector:**



A large, stylized handwritten signature in black ink.

Date: Thursday, 18/12/2008 9:12:35 AM  
 User: Julie Dawson

## Process Sheet

|                                  |  |                         |                         |
|----------------------------------|--|-------------------------|-------------------------|
| <b>Customer</b>                  | : CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b>     | : 350/355 AS X-TUBE AFT |
| <b>Job Number</b>                | : 42538  |                         |                         |
| <b>Estimate Number</b>           | : 12486  |                         |                         |
| <b>P.O. Number</b>               | :  | <b>Part Number</b>      | : D350748201            |
| <b>This Issue</b>                | : 18/12/2008   | <b>S.O. No.</b>         | :                       |
| <b>Prsht Rev.</b>                | : NC   | <b>Drawing Number</b>   | : N/A                   |
| <b>First Issue</b>               | : 10/10/2008   | <b>Project Number</b>   | : N/A                   |
| <b>Previous Run</b>              | : 42537  | <b>Drawing Revision</b> | : D                     |
|                                  |  | <b>Material</b>         | :                       |
| <b>Written By</b>                | :  | <b>Due Date</b>         | : 22/10/2008            |
| <b>Checked &amp; Approved By</b> | :  | <b>Qty:</b>             | 1 Um: Each              |
| <b>Comment</b>                   | : Est Rev: A New Issue 06-07-05 JLM<br>: Est Rev: B Update qty of MS21042L5 06-09-12 KJ<br>: Est Rev C Combined manufacturing 08.04.02 EC verified by:<br>DD<br>: Est Rev:D 08-06-24 revD as per dwg DD verified by:EC |                         |                         |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

1.0

DC

DOCUMENT CONTROL



JUD 08.12.18



**Comment:** Photocopy bluefile & type labels per PPPD350-748-201 CHG001

2.0

D350748241TRN

Crosstube Turning Detail



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 CROSSTUBE TURNING DETAIL  
 batch \_\_\_\_\_

3.0

BENDING

BENDING MACHINE - SKIDTUBES



**Comment:** BENDING MACHINE  
 Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT \_\_\_\_\_

Job Completion

